

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005097**Date Inspected:** 20-Dec-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 830**OSM Departure Time:** 1730**Location:** Muroran, Japan**CWI Name:** Chung Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:****Steel Structure Shop:**

Tower saddle Casting T1-1: Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau traveled to Japan Steel Works (JSW) Muroran plant to observe two welders perform buttering repair welding on two stems of T1-1 tower saddle casting portion. This buttering repair welding is approved by Submittal 000643 Rev. 5. The buttering repair welding is buildup metal welding utilizing the Shielded Metal Arc Welding (SMAW) process conducted by welders performed in the flat position. The area is 2270mm length x 50mm width x 3mm thick has been welding along center of stem. The proper filler metal used for SMAW welding is Hoballoy 9018-M with 5mm diameter electrode made by Hobart Brothers, USA. The SMAW welding process and parameters per Caltrans approved WPS # SJ-3012-1-1, also monitored and recorded by CWI inspector Mr. Chung Kuan. Based on Caltrans QA observation, the buildup SMAW welding operation appeared to be in general compliance with requirements of AWS D1.5 2002 and Caltrans contract documents. The buildup metal area is scheduled for grinding on December 23, 2008.

WELDING INSPECTION REPORT

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Summary of Conversations:

As noted within the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Lanz, Joe	QA Reviewer
